



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

5237245
RBE350A94-3700-C
Job Sheet R203673



Part No: RBE350A94-3700-C

Job Qty: 2 pcs

Part Name: Swashplate Immobilizing Tools Adjustable Brace



Part Weight: 0 lbs

Status: New

Job Created: 11/25/19

Job Tracking No: rusted - needs rework

Due Date: 12/16/19

Created By: Linda Lacelle

Type: Rework

Description:

Note: URF 19-961 DWG RBE350A94-3700-C Rev 6 IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

POSITIVE RECALL

EFFECTIVE *12/10/19* AUTH *S. L.*

RELEASED *12/10/19* DATE *12/10/19*

PRIORITY: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
111	Rework - 1 - Startup	2 pcs	12/16/19		0.00	0.20	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
							Small Fab - 9 - B4B		
112	Rework - 2 - B4B	2 pcs	12/16/19		0.00	0.33	Handfinish - 7 - 1 - B4B		GP 19-12-04 BEB 19-12-05
							Handfinish - 7 - 2 - B4B		
113	Rework - 3 - B4B	2 pcs	12/16/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
114	Outsource - 7 - Rework	2 pcs	12/16/19				GRO002-VC		2019-12-12

115 Rework - 4 - B4B

2 pcs

12/16/19

0.00 0.00

Packaging 2 - 1 - B4B

Packaging 2 - 2 - B4B

Packaging 2 - 3 - B4B

Packaging 2 - 5 - B4B

Packaging 2 - 4 - B4B

Packaging 2 - 6 - B4B

Packaging 2 - 7 - B4B

Packaging 2 - 8 - B4B

Packaging 2 - 9 - B4B

Packaging 2 - 10 - B4B

Packaging 2 - 11 - B4B

Packaging 2 - 12 - B4B

Packaging 2 - 13 - B4B

Packaging 2 - 14 - B4B

Packaging 2 - 15 - B4B

Packaging 2 - 16 - B4B

Packaging 2 - 17 - B4B

Packaging 2 - 18 - B4B

Packaging 2 - 19 - B4B

Packaging 2 - 20 - B4B

Packaging 2 - 21 - B4B

Packaging 2 - 22 - B4B

Packaging 2 - 23 - B4B

Packaging 2 - 24 - B4B

Packaging 2 - 25 - B4B

Packaging 2 - 26 - B4B

Packaging 2 - 27 - B4B

Packaging 2 - 28 - B4B

Packaging 2 - 29 - B4B

Packaging 2 - 30 - B4B

Packaging 2 - 31 - B4B

Packaging 2 - 32 - B4B

Packaging 2 - 33 - B4B

Packaging 2 - 34 - B4B

Packaging 2 - 35 - B4B

Packaging 2 - 36 - B4B

OP

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116 Rework - 5 - B4B

2 pcs

12/16/19

0.00 0.00

QC 6 - 9

QC 6 - 68

QC 6 - 61

QC 6 - 40

QC 6 - 81

DAS

JAN 02 2020 68

9-89

117 Rework - 6 - B4B

2 pcs

12/16/19

0.00 0.50

Small Fab - 1 - B4B

Small Fab - 2 - B4B

Small Fab - 3 - B4B

Small Fab - 4 - B4B

Small Fab - 5 - B4B

Small Fab - 6 - B4B

Small Fab - 7 - B4B

Small Fab - 8 - B4B

Small Fab - 9 - B4B

OP 20-01-06.

120 QC 5

2 pcs

12/16/19

0.00 0.00

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40 9-88 JAN 06 2020
				QC 5 - 61	
				QC 5 - 81	
130 Packaging 3-1 - Stock - B4B 2 pcs	12/16/19	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	2 pcs	12/16/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	DAS 21 9-88 JAN 07 2020

Part Op 111 - 1-Disassemble. Bag parts to be reworked (black oxide) accordingly for outsource supplier and identify material type
 Descriptions: as per drawing. 2-Identify hardware accordingly for reassembly at sequence 117.
 112 - 1-Bead blast, remove rust and black oxide.
 113 - (QC5- Inspect part completeness to step on W/O)
 114 - -Issue P/O; 4532 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM, Stress Proof & B7 -Certificate of Conformity is required
 115 - (Pac2-Receive & Inspect for Damage & Mat'l Certs.)
 116 - (QC6- All purchased or subcontracted products)
 117 - 1-Re assemble using previously removed parts at sequence 111. 2-Replace old roll pins with new ones.
 120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A94-3700-C	Swashplate Immobilizing Tools Adjustable Brace	2 pcs (1 ea)	111-Rework - 1 - Startup	5234479.
92373A181	Roll Pin 1/8 X 3/4 203	6/4 Ea (2 ea)	117-Rework - 6 - B4B	5161590
92373A251	Slotted Spring Pin 54.	6/2 Ea (1 ea)	117-Rework - 6 - B4B	214323

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
111-Rework - 1 - Startup	RBE350A94-3700-C	2	0	0
117-Rework - 6 - B4B	92373A181	4	148	0
	92373A251	2	85	0

Part Specifications

Specifications could not be found.

Plex 11/25/19 10:22 AM dart.lacelle.linda



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045382**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045382

PO Date: 12/12/19

Due Date: 12/20/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pyint Terms: Net 60

Freight Terms:

Special Comments:

RE USE

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	R203653	RBE350A94-3700-A	RBE350A94-3700-A Rev 7	Swashplate Immobilizing Tools Long Brace & Parts -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-C- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM & Stress Proof -Certificate of Conformity is required	Firmed	-	12/20/19	6 pcs	0 pcs	6 pcs	\$5.2738461/pcs	\$31.64

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PURCHASE ORDER

POHB045382



Items

Line	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	R203654	RBE350A94-3700-B	RBE350A94-3700-B Rev 6	Swashplate Immobilizing Tool, Short Brace Assembly -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM & Stress Proof & 1018 -Certificate of Conformity is required	Firmed	-	12/20/19	6 pcs	0 pcs	6 pcs	\$5.2738461/pcs	\$31.64
3	R203657	RBE350A94-2708-01	RBE350A94-2708-01 Rev G	Tail Rotor Blade Locking Tool -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1144 Stress Proof -Certificate of Conformity is required	Firmed	-	12/20/19	2 pcs	0 pcs	2 pcs	\$5.2738461/pcs	\$10.55
4	203752	RBE117-12140W9	RBE117-12140W9 Rev A	Mount (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	12/20/19	6 pcs	0 pcs	6 pcs	\$5.2738461/pcs	\$31.64



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Canada

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PURCHASE ORDER POHB045382



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	R203673	RBE350A94-3700-C	RBE350A94-3700-C Rev 6	Swashplate Immobilizing Tools Adjustable Brace -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-C- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM, Stress Proof & B7 -Certificate of Conformity is required	Firmed	-	12/20/19	6 pcs	0 pcs	6 pcs	\$5.2738461/pcs	\$31.64
Grand Total:												\$137.12

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/17/19 11:15 AM Dart.Lavoie.Chantal



Certificat de Conformité / Certificate of Compliance

(024974-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

024974-1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No		Bon de commande Client Customer Purchase Order No.			
17-Dec-2019		Jigar Patel				POHB045382			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBE350A94-3700-A Rev.7	RBE350A94-3700-A OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309, TYPE - 3 OR MILL - C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS OIL	OXIDE-BLACK CH	6	6	0	0	0	
2	RBE350A94-3700-B Rev.6	RBE350A94-3700-B OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309, TYPE - 3 OR MILL - C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS OIL	BLACK-OXIDE CH	6	6	0	0	0	
3	RBE350A94-2708-01 Rev.G	RBE350A94-2708-01 O1 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	2	2	0	0	0	
4	RBE117-12140W9 Rev.A	RBE117-12140W9 O1 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1, MIL-C-13964 GRADE 4	OXIDE-BLACK CH	6	6	0	0	0	
5	RBE350A94-3700-C Rev.6	RBE350A94-3700-C OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C, CLASS 1 APPLY THIN LAYER OF OIL /CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESSO1 - OXIDE-BLK & OIL [OXIDE BLACK AND OIL]	BLACK-OXIDE CH	6	6	0	0	0	

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DART AEROSPACE LTD.

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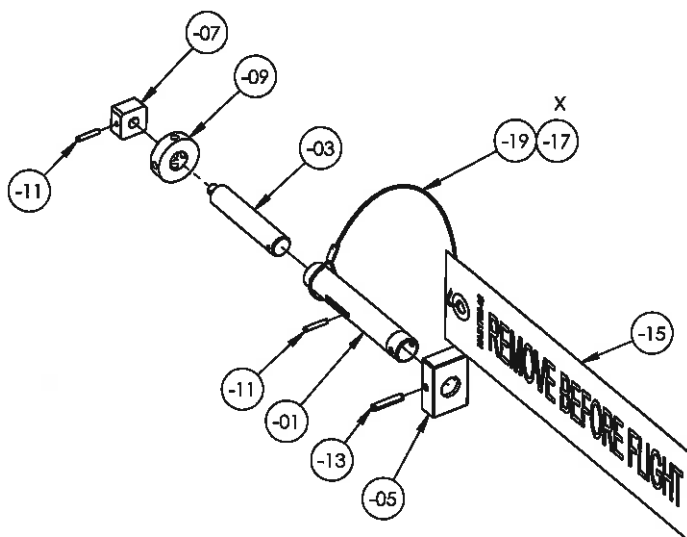
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BUYER:

Page 2 of 2

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
6	16-0286	-1A ADDED DRAWING.	2/28/2017	RJC
				SM



ADJUSTABLE BRACE ASSEMBLY

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE	
DWG NO. RBE350A94-3700-C-1A	REV 6
MAT'L	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS 3/16
SPEC	.XX ± .01 ANGLES ±.2°
	.X ± .1 SURFACES ±.125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 ±.005 OR .0156
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: MACKOVJAK	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	EUROCOPTER AS350/355
SCALE 1:4	DATE 8/21/2012
	SHEET 2 OF 7